

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015126**Date Inspected:** 24-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China

CWI Name:	Mr.Gong Wei			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

In process Inspection

Out Side Yard

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 11BE, weld No: SSD17-PP099-180. The welder is identified as #216086. ZPMC QC is identified as Mr.Wang wei ming. The welding variables recorded by QC appear to comply with WPS-B-P-2113-TC-U4b-FCM-1.

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 11BE, weld No: SSD17-PP099-180. The welder is identified as #216086. ZPMC QC is identified as Mr.Wang wei ming. The welding variables recorded by QC appear to comply with WPS-B-P-2113-FCM-1.

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 11BE, weld No: SEG068A-039. The welder is identified as #066258. ZPMC QC is identified as Mr.Wang wei ming. The welding variables recorded by QC appear to comply with WPS-B-P-2114-TC-U4b-FCM.

WELDING INSPECTION REPORT

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Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13AE Side Plate, weld No. SP3062-001-015/016. The welders are identified as #044830, 044795. ZPMC QC is identified as Mr. Zhang guo hui. The welding variables recorded by QC appear to comply with WPS-B-T-2132. Please see the attached picture.

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13AE Side Plate, weld No. SP3062-001-029/30. The welders are identified as #050242, 044801. ZPMC QC is identified as Mr. Zhang guo hui. The welding variables recorded by QC appear to comply with WPS-B-T-2132. Please see the attached picture.

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13AE Side Plate, weld No. SP3062-001-057/058. The welders are identified as #044774, 055491. ZPMC QC is identified as Mr. Zhang guo hui. The welding variables recorded by QC appear to comply with WPS-B-T-2132. Please see the attached picture.

Bay #16

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AW bottom Plate, weld No. BP3074-001-001. The welder is identified as #045270. ZPMC QC is identified as Mr. Xia Chen hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3c-S-2. Please see the attached picture.

Magnetic Particle Testing:-

Bay #19

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Suspender Bracket. The weld designation reviewed is as follows:

SB013-066-025.

Out Side Yard

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as Panel point angle plate. The weld designation reviewed is as follows:

SSD22-PP92.5-174,175,005,006,007,008

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Pandaram

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer